

Work Order ID 131492

Friday, April 10, 2015 7:56:12 AM

RLC

131492

Page 1

Item ID: D2842-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly RH, 206 Float

Start Date: 4/10/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/10/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MJS

Date: 15-04-10

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2842	Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.02

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 ***DO NOT OPEN HOLES***
3-Deburr and bevel ends for welding

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

2

SEP 02 2015

DAS
24
9-89

2x

DAS
43
9-89

SEP 04 2015

Work Order ID 131492

Friday, April 10, 2015 7:56:12 AM

131492

Page 2

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

Weld per dwg A/R Aluminum rod Batch: **130855** 0.00

110

Large Fab

Memo

0.03

2

SEP 10 2015

**DAS
24
9-89**

Large Fab

1-Weld one end cap and (2) lugs using DT10058 as per Dwg D2842

2- OPEN HOLES TO SIZE AS PER DWG (0.250")

3-Grind end cap weld flush

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

2

**DAS
43
9-89**

SEP 10 2015

Quality Control

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

2

**DAS
43
9-89**

SEP 10 2015

Quality Control

Work Order ID 131492

Friday, April 10, 2015 7:56:12 AM

131492

Page 3

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2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.02

Hand Finishing

2 15-9-10 JH

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

② 15-09-10 PD

160

Weld per dwg A/R Aluminum rod Batch: 130855 0.00

160

Large Fab

Memo

0.02

Large Fab

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.

2 SEP 11 2015

DAS
24
9-89

Work Order ID 131492

131492

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2

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170						2			
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180						2			
QC	Memo	0.00							
Quality Control									
185	Pressure Wash per QSI005 4.3	0.00							
185						2	0		
HandFinish	Memo	0.01							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

SEP 14 2015

SEP 14 2015

15-9-14

Work Order ID 131492

131492

Page 5

Friday, April 10, 2015 7:56:12 AM

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Required Date: 4/10/2015 Req'd Qty: 2.00

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Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

190

M131545

Powdercoat

Memo

0.01

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320°
11:00

2 of 15-9-16 2:30

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

2 of 15-9-16 11:00

210

HandFinishing

0.00

210

HandFinish

Memo

0.03

Hand Finishing

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: M131545

2 of 15-9-16 11:00

DAS
15
9-89

Work Order ID 131492

Friday, April 10, 2015 7:56:12 AM

131492

Page 6

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Cust Item ID:

Required Date: 4/10/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.00

Quality Control

DAS

38

9-89

SEP 17 2015

230

Identify as per dwg & Stock Location: _____

0.00

230

Packaging

Memo

0.00

Packaging

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

DAS

6

9-89

SEP 18 2015

SEP 18 2015

SEP 18 2015

SEP 18 2015

Picklist Print

Friday, April 10, 2015 7:56:19 AM

Page 1

Work Order ID: 131492

131492

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 4/10/2015

Required Date: 4/10/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0332R		Purchased	No			100	Each	5,554.000	3	6			
NAS1149C0332R									**		all is/oc/12		
WASHER													

Location	Loc Qty	Loc Code
FP001	2174	
123248	34	
m130325	2140	
GA	786	
m131618	786	
ST260a	2570	
m131697	2570	
ST271	24	
m131340	24	

D2622-120C

Manufactured No

110

Each

151.9200

1

2

**

SEP 02 2015

DAS
24
9-89

D2622-120C

Step Extrusion

Location	Loc Qty	Loc Code
WA003	151.92	
125381	25.92	
130161	126	

D2734

Manufactured No

110

Each

89.0000

2

4

**

SEP 02 2015

DAS
24
9-89

D2734

Step End Plate

Location	Loc Qty	Loc Code
WA003	89	
130457	29	
130983	60	

Picklist Print

Friday, April 10, 2015 7:56:19 AM

Page 2

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131492

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 4/10/2015

Required Date: 4/10/2015

Start Qty: 2.00

Required Qty: 2.00

D3459-1 Manufactured No

110 Each 41.0000 2 4

D3459-1

Float Step Mounting Plate

**

SEP 02 2015

DAS
24
9-89

Location	Loc Qty	Loc Code
WA003	41	
125376	6	
126297	6	
130003	12	
130490	17	

D3459-3 Manufactured No

210 Each 48.0000 2 4

D3459-3

Float Step Mounting Plate

**

SEP 02 2015

DAS
24
9-89

Location	Loc Qty	Loc Code
WA003	48	
125129	6	
125762	6	
126298	6	
129735	10	
130491	20	

MS27039C1-07 Purchased No

210 Each 68.0000 3 6

MS27039C1-07

screw

**

all 15/09/16

Location	Loc Qty	Loc Code
ST283	68	
m130566	13	
m131624	50	

11132317

x6

Friday, April 10, 2015 7:56:19 AM

Shop Packet Print

Page 2

Picklist Print

Friday, April 10, 2015 7:56:19 AM

Page 3

Work Order ID: 131492

Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

131492

D2842-042

Start Date: 4/10/2015

Required Date: 4/10/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1329C3KB130

Purchased

No

210

Each

63.0000

3

6

NAS1329C3KB130

Insert

**

all 15/04/16

Location

Loc Qty

Loc Code

FP001

23

m129207

21

m130281

2

ST267

40

131677

40

XL

NAS1515H3L

Purchased

No

210

Each

421.0000

3

6

***NAS1515H3I ***

Washer

**

all 15/04/16

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

326

m127831

48

m130726

278

XL

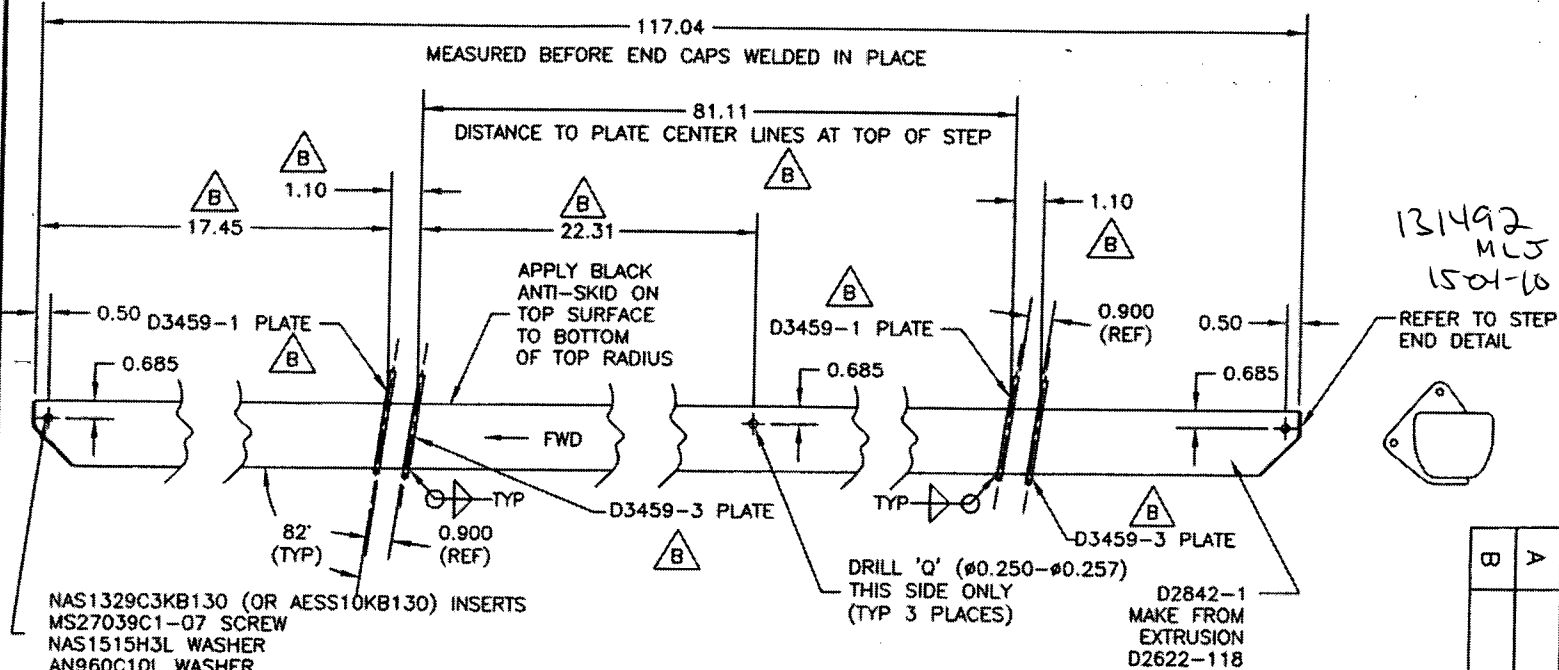
Friday, April 10, 2015 7:56:19 AM

Shop Packet Print

Page 3



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23	DATE 05.09.23	REV. B
		SHEET 1 OF 1
		SCALE
		206L/407 FLOAT STEP ASSEMBLY
		RE-DESIGN, ADD D3459-1/-3
		NTS

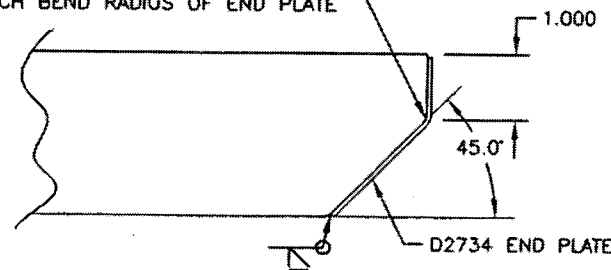


D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14